

# Work Order ID 85197

June-04-12 1:33:44 PM

**\*85197\***

Page 1

ASAP

Item ID: D4078-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clamp Half

Start Date: 04/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4078	B

100

0.00

**\*100\***

Bandsaw

Memo

0.00

JK 12-06-06

(12)

Jeaspa Bandsaw

Cut blank 2.700" long

110

0.00

**\*110\***

HAAS 1

Memo

0.00

29 12-6-8

12

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev:

Dwg Rev:

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*FAI 12-6-8*

**\*120\***

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

*and 12/06/08*

**\*130\***

QC

Memo

0.00

*12 10*

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

*12 7/5 12-8-11*

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Start Time: 2:10

12X ✓

MT  
12/06/11

**\*150\***

Powdercoat

Memo

0.00

Temp 1320 °F

Finish Time: 2:40

Powder Coating

W121274

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

12 6 12/06/11

Quality Control

170

Identify as per dwg & Stock Location: 5191

0.00

**\*170\***

Packaging

Memo

0.00

12 545 12/06/12

Packaging

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 04/06/2012      **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 18/06/2012      **Req'd Qty:** 12.00

\*12\*

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date:

**Tooling:**

Date:

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

## Operation Description

### Set Up/ Run Hours

## Tool ID

**Tool #**

## Plan Code

**Accept  
Qty**

Reject  
Qty

## Reject Number

**Insp.  
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

12/6/12 JJ

2/2-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 85197

**\*85197\***

Parent Item: D4078-1

**\*D4078-1\***

Parent Item Name: Clamp Half

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	18.2900	0.223	2.816842			

**\*M6061T6B1 250X01 250\***

**\*\***

*Rg 12.6.8*

6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT004

18.29

119318

18.29

2.82

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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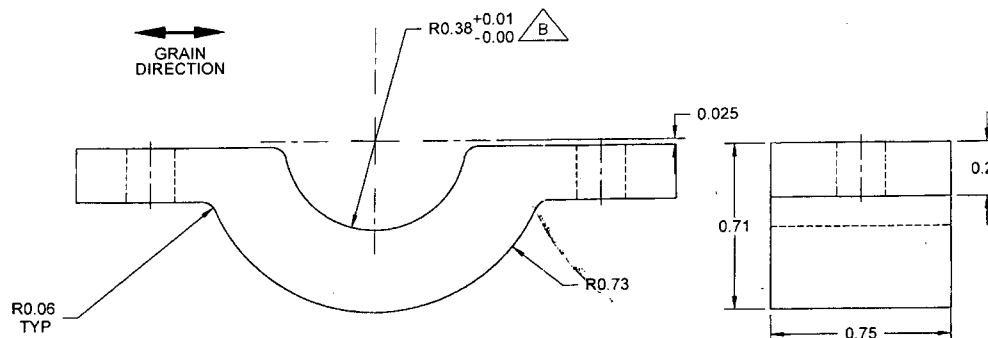
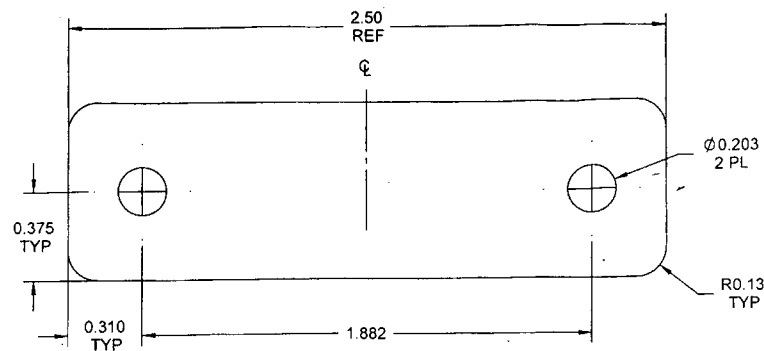
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4078-1 CLAMP HALF**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85197 MLJ  
12/06/04

**RELEASED**  
2010-09-07  
*WP*

B	R0.38 was R0.48.	<i>LB</i>	10.07.30
A	NEW ISSUE	<i>LB</i>	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>LB</i>		
DRAWN	<i>LB</i>		
CHECKED	<i>LB</i>		
MFG. APPR.	<i>LB</i>		
APPROVED	<i>WP</i>		
DE APPR.	<i>WP</i>		
DATE	10.07.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWING NO. <b>D4078</b>	SHEET 1 OF 1
TITLE <b>CLAMP HALF</b>	SCALE NTS
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*38*  
*38*  
*16*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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